

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025843**Date Inspected:** 08-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A
Bridge No:	34-0006	Component:	OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Trial Assembly Area

Caltrans and ABF have agreed to conduct visual and magnetic particle (MT) inspections of welds as part of a special joint inspection program. In response to ZPMC NDT Inspection Notification Sheets (NWIT) #09665 for MT inspection of the following:

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date and provided a turnover to dayshift personnel for tracking of these welds. The members were identified as follows:

OBG Segment 13AE, SEG3071-001. The weld designations reviewed were: 061, 062. No apparent VT or MT indications were observed.

OBG Segment 13AE, SEG3007C. The weld designations reviewed were: 179, 321, 322, 323, 324, 224, 225, 226, 227. No apparent VT or MT indications were observed. Numerous arc strikes were observed in the area of these welds. This QA Inspector marked them as arc strikes and informed ABF inspectors of the need for the arc strikes to be ground and subsequently, have MT performed by ZPMC or ABF.

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OBG Segment 13AE, SEG3007Q. Weld designation 083 was also listed on NWIT #09665 and accepted by ZPMC inspectors. ZPMC Inspectors reported no apparent VT or MT indications were observed.

OBG Segment 13AE, VP3004-001. The weld designation reviewed was: 009. No apparent VT or MT indications were observed. Weld joint VP3004-001-004 was also listed on NWIT #09665 and accepted by ABF inspectors. However, this QA Inspector rejected the weld based on VT and did not perform MT on this weld for that reason. The cope hole at the end of the weld was angled approximately 45 degrees across the thickness of the I-rib and the cope hole displayed a rough surface.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
